

Work Order ID 118402

\*118402\*

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September-04-14 3:13:43 PM

Item ID: D119-646-211

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube with Run-On Landing Wearplates LH

Start Date: 9/04/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 9/12/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference: REWORK RS1015

Approvals: Process Plan: OK Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D119-646	B

100 Document Control SL 0.00

\*100\*

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D119-646-211  
CHG004

DAS  
3  
9-68

OCT 31 2014

101 0.00

\*101\*

Skidtubes

Memo

0.00

Skidtubes

PULL FROM STK:  
1 X D119-646-211 B122218 CHG004

FWD GHW HOLES DO NOT ALIGN  
REWORK PER RS1015

KEEP ORIGINAL KIT AND PUT ASIDE TO BE REPACKAGED ONCE  
TUBE IS REWORKED

14-9-5

<b>DART</b>		1270 ABERDEEN ST HAWKESBURY ON CANADA K6A 1K7 TEL 1-800-332-3200 www.darterspace.com	
PATENT	US #5735484 / CA #2222184 / EURO #0828655		
P/N	D119-646-211	CHG	CHG004
DESC	Skidtube STD, LH	STC	SR02024SE
LOT	B122218	STC	
MODEL	Agusta A119/AW119MKII	STC	
TO APPROVAL #09-09		MADE IN CANADA	

B118402 LH

# Work Order ID 118402

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Item ID:	D119-646-211	Accept	<b>*N900040100*</b>	Setup	Start	<b>*NS1*</b>
Revision ID:					Stop	<b>*NS2*</b>
Item Name:	Skidtube with Run-On Landing Wearplates LH					
Start Date:	9/04/14	Start Qty:	1.00	<b>*1*</b>	Cust Item ID:	
Required Date:	9/12/14	Req'd Qty:	1.00	<b>*1*</b>	Customer:	
Reference:	REWORK RS1015					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
102		0.00							
<b>*102*</b>									
HandFinish	Memo	0.00							
Hand Finishing	REMOVE FWD AND AFT CAP -SET ASIDE TO RE-INSTALL CLEAN OFF SIKAFLEX								
103	QC5- Inspect part completeness to step on W/O	0.00							
<b>*103*</b>									
QC	Memo	0.00							
Quality Control									

1 0 86-14-0705

NIA 14-9-5

# Work Order ID 118402

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Item ID: D119-646-211 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube with Run-On Landing Wearplates LH  
 Start Date: 9/04/14 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 9/12/14 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: REWORK RS1015

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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104

0.00

\*104\*

Skidtubes

Skidtubes

Memo

0.00

1-DRILL OUT AND REMOVE CROSS BOLT SPACERS D2579 IN  
 DETAIL C ON DWG D3887

2-REPOSITION LOCATION OF HOLES AS PER DWG BUT USING  
 +/-0.005" TOL AND PER SYMMETRICAL IN QSI 018

3- TACK ONLY CROSS BOLT SPACERS D2579 B 113785 \*2

4-REAM HOLES TO MAX TOLERANCE AS PER QSI018

5-TEST FIT GRD HANDLING FIXTURE

BE1409-05

14-9-8

105

QC5- Inspect part completeness to step on W/O

0.00

\*105\*

QC

Quality Control

Memo

0.00

LOCATION MUST BE VERIFIED BY QC  
 RECORD DIMS:

105.1 Outsource - send to JMI for paint stripping  
 PO 25865

105.2 Packaging - Ream + Inspect

105.3 QC - QCB 5/14/12

C/L 14/09/22 ①

1X SP 14-10-14

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Item ID: D119-646-211 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube with Run-On Landing Wearplates LH  
 Start Date: 9/04/14 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 9/12/14 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: REWORK RS1015

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
106		0.00							
*106*	HandFinish								
Hand Finishing	106.1 Powder coat - re powder coat per Q5005	0.00							
	Memo: Rebuild line 11/16/14 0.00 (K) M109808. START: 10:00 OVEN T: 320° FINISH: 10:30.								
107	QC Inspect Chemical Conversion Coat	0.00							
*107*	QC								
Quality Control	108 - Hand Finishing - Reassemble using original parts => 1 x d	0.00							
109	QC - QC 5								
110	Pick Kit	0.00							
*110*	Packaging								
Packaging	Memo: ENSURE ORIGINAL KIT IS IN BOX	0.00							

OCT 31 2014

**Work Order ID 118402****\*118402\***

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Item ID: D119-646-211 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Skidtube with Run-On Landing Wearplates LH  
Start Date: 9/04/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 9/12/14 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference: REWORK RS1015

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00							
			DAS 05 9-09						Oct 31 2014
130 <b>*130*</b> Packaging Packaging	Memo REPACKAGE USING NEW B.N Identify and pack for shipping as per PPP D119-646-211 Location: <u>084</u> PPP rev: _____	0.00  0.00							
			DAS 05 9-09						Oct 31 2014
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

14/11/3  
10-31

# Picklist Print

September-04-14 3:13:42 PM

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Work Order ID: 118402

**\*118402\***

Parent Item: D119-646-211

**\*D119-646-211\***

Parent Item Name: Skidtube with Run-On Landing Wearplates LH

Start Date: 9/04/14

Required Date: 9/12/14

Start Qty: 1.00

Required Qty: 1.00

**Comments:**

IPP RevA: New issue DD verified by:EC  
 12.09.12 as per ECN12-644 DD verf:JLM IPP Rev:B  
 12.11.05  
 raise to chg003 (ECN 12-675) DD verf:JLM IPP REV:D 13.03.20 raise to  
 chg004 (ECN 13-534) DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D119-646-211

Manufactured

No

Each

2.0000

1

**\*D119-646-211\***

Skidtube with Run-On Landing Wearplates LH

\*\*

B/22218

Location

Loc Qty

Loc Code

FG084

2

120985

1

122219

1

*[Handwritten signature]*  
 14-9-5

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 118402
<b>Description:</b> Repair Scheme D119-646-241 Skid tubes FWD GHW holes do not align NCR 14-3771 For tubes in production and Returned tubes		
<b>Drawing:</b> D3887	<b>Repair Scheme:</b>	<b>RS1015</b>
<b>Part No:</b> D119-646-241	<b>Page:</b>	<b>1 of 1</b>
<b>Batch No:</b>	<b>Qty:</b>	<b>1</b>

Step	Location	Procedure	By	Date	Qty
1	Finishing	Remove FWD & AFT caps D2855-3. Clean all sikaflex off cap & identify per each tube caps was removed (P/N & B#)	BE	14-09-05	1
2	Skidtube	Drill out & remove FWD Cross bolt spacers D2579 in Detail C on Dwg D3887	BE	14-09-05	1
3	Skidtube	Reposition location of holes as per Drawing but using <u>+/-0.005" tol</u> and per symmetrical in QSI 018	BE	14-09-05	1
4	Skidtube	TACK ONLY Cross bolt spacers D2579 B <u>113785</u> x2	BE	14-09-05	1
5	QC	Location MUST be verified by QC Record Dims HERE <i>Fitted Sig</i>		14-10-08	
6	Skidtube	Weld as per QSI 004 A/R <u>M129399</u> Back Drill Grind welds flush & deburr	BE	14-09-08	1
7	QC	QC 10 & 5 Inspection <b>***TEST FIT GHW WHEELS***</b> <u>Pass</u> <input type="checkbox"/> <i>Fitted Sig</i>	DP	14-9-8	
8	Finishing	Touch up alodine as per QSI 005	BE	14-10-08	x1
9	Finishing	Touch up Powder coat per QSI 005	BE	14-10-20	
10	Finishing	Re-assemble original caps back on tubes Sikaflex B <u>M130222</u> exp <u>15/04</u>	BE	14-10-27	1
11	QC	QC 3 inspect	DAS 38 9-89	14-10-27	1
12	QC	QC 5 inspect	DAS 49 38 9-89	14-10-27	1
13	QC	QC21			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.04.29	New Issue	ED		

U:\Admin\Forms\Repairschemb\A.doc

Rev. A

**DART**  
AEROSPACE

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO25865**

Purchase Order Date 9/22/2014

PO Print Date 9/22/2014

Page Number 2 of 3

**Order From :**

VC-IMI001

**Ship To :** DART AEROSPACE LTD

IMI MANUFACTURING INC.  
772 MAIN ST. E.P.O. BOX 3  
HAWKESBURY, ON K6A 2R4  
CA

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone**

613 675 1208 Ext.223

**Ship To Contact**

**Ship To Phone**

**Ship Via:**

**Ship Acct:**

**Buyer**

**Customer POID**

**Customer Tax #**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

EXW - (Ex Works)

3	118402	D119-646-211 Skidtube	9/22/2014	1.00	\$50.00	\$50.0
			Yes			
			9/26/2014			

To cover the cost of pain stripping.  
Strip product supplied.  
B118402

**Line Total:** \$50.0

4	122803	D119-646-241 skidtube	9/22/2014	1.00	\$50.00	\$50.0
			Yes			
			9/26/2014			

To cover the cost of pain stripping.  
Strip product supplied.  
B122803

**Line Total:** \$50.0

5	122804	D119-646-241 Skidtube	9/22/2014	1.00	\$50.00	\$50.0
			Yes			
			9/26/2014			

To cover the cost of pain stripping.  
Strip product supplied.  
B122804

**Note:**

9/22/2014

SP 14-10-14





# Manufacturing Inc.

2056 County Rd #4, L'Original, Ontario K0b 1K0

Phone 613-675-1208

Fax 613-675-1250

## PACKING SLIP

TO : DART AEROSPACE  
1270 Aberdeen Street  
Hawkesbury ON  
K6A 1K7

Date : October 14 2014

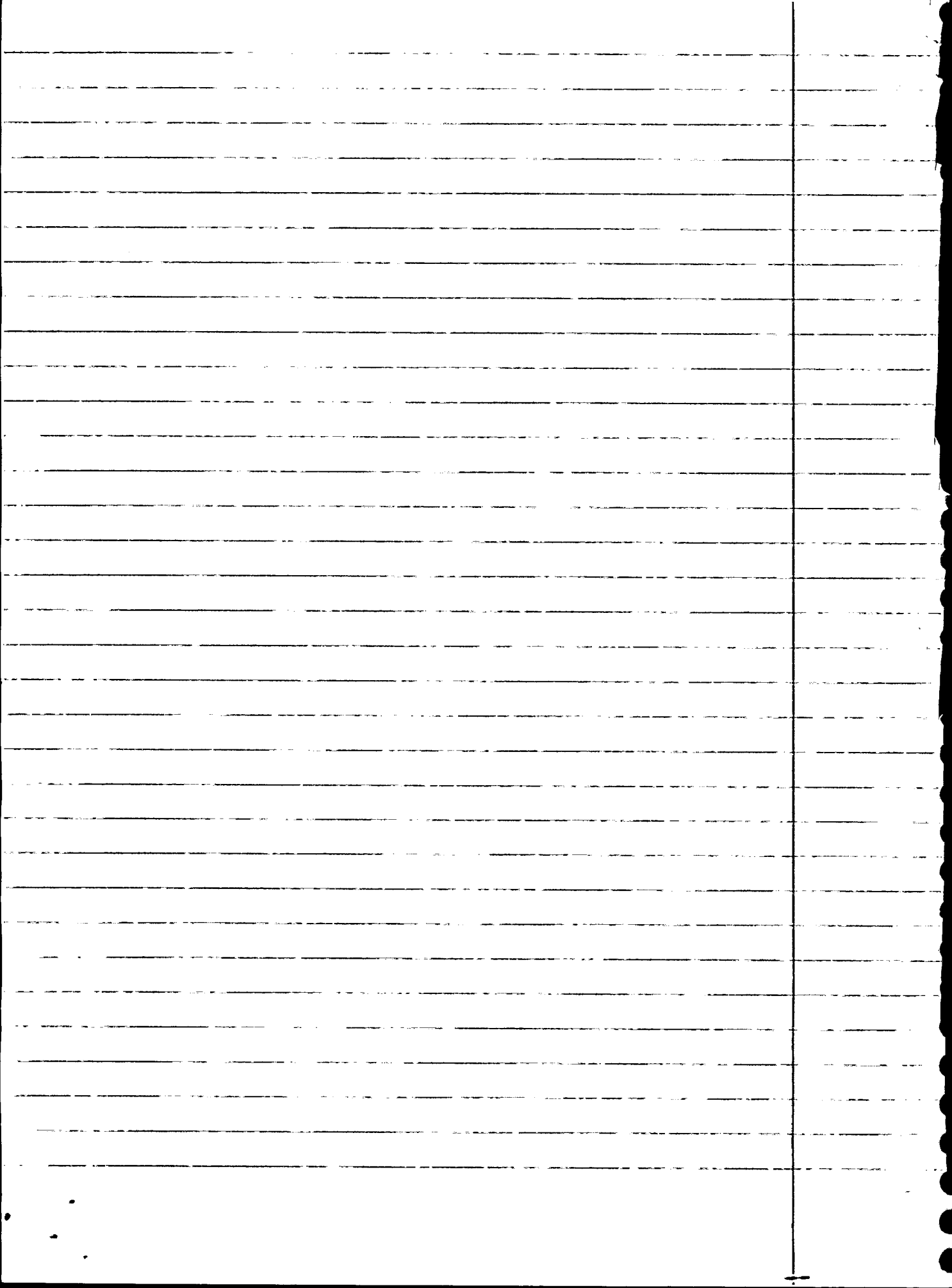
SALESPERSON:		JOB # 14-0464-22	PO NUMBER : 25865	
QTY ORDER	DESCRIPTION		QTY SHIP	LINE TOTAL
6	SKIDTUBE		6 ✓	1
8014-10-14.				

Client: (PRINT NAME) \_\_\_\_\_ (SIGNATURE) \_\_\_\_\_

THANK YOU FOR YOUR BUSINESS!

# New Parts:

Part No:	Batch No:	Qty:
02855-3	0117601	(x2)
03672-1	M113581	(x2)
03904-1	M113662	<del>(x2)</del> (x16)
AN3C-5A	M1B0358	(x2)
AN3C-46A	M128991	(x8)
M521043-3	M130186	(x3)
M521043-3	M130673	(x8)
M524894-C52	X1127055	(x2)



Work-Order ID 118402

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\*118402\*

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Item ID: D119-646-211 Accept \*N900040100\* Setup Start \*NS1\*  
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 Item Name: Skidtube with Run-On Landing Wearplates LH  
 Start Date: 9/04/14 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 9/12/14 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: REWORK RS1015

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D119-646	B

100 Document Control 0.00  
 \*100\*  
 DC Memo 0.00  
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D119-646-211  
 CHG004

SP  
 Label  
 Blanc x2

101 0.00  
 \*101\*  
 Skidtubes Memo 0.00  
 Skidtubes PULL FROM STK:  
 1 X D119-646-211 B122218

FWD GHW HOLES DO NOT ALIGN  
 REWORK PER RS1015

KEEP ORIGINAL KIT AND PUT ASIDE TO BE REPACKAGED ONCE  
 TUBE IS REWORED

14-9-5

<b>DART</b> AEROSPACE		1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7 TEL: 1-810-632-9200 / www.dartaerospace.com	
PATENT	US #5735484 / CA #2222184 / EURO #0828655	CHG	CHG004
P/N	D119-646-211	STC	SR02024SE
DESC.	Skidtube STD, LH	STC	
LOT	B122218	STC	
MODEL	Agusta A119/AW119MKII	STC	